

Table 3

	Comp. Ex. 1	Comp. Ex. 2	Comp. Ex. 3	Comp. Ex. 4	Comp. Ex. 5
Curable resin composition	(2)/(3) = 80/20(%)	(4) 100(%)	(1)/(2) = 45/55(%)	(1)/(2) = 45/55(%)	None
Elongation percentage (%)	64	1.7	28	28	None
Barcol hardness	40 (HBI-B)	44 (HBI-A) 76 (HBI-B)	60 (HBI-B)	60 (HBI-B)	--
Tensile strength (MPa)	7	60	15	15	--
HDT (°C)	RT	112	RT	RT	--
Amt. of filler (parts)					None
Calc. Carb. SS-80	77	77			
Calc. Carb. SS-30			25		
Calc. Carb. R				170	
Hollow filler*	3	3	--	--	
Amt. of thixotropic agent	2.3 Aerosil #200	2.3 Aerosil #200	1.3 Aerosil #200	2.3 Aerosil #200	None
Intermediate layer comp.					None
Viscosity	38.7	41.2	19.3	140	
Thixotropy	6.8	7.1	5.6	6.1	
Surface smoothness				Not sprayable	
After demolding	19.0	19.8	18.2		17.0
After 72 hours	14.6	18.7	14.1		15.2
Cracking deflection (mm)	5.0	1.8	3.0	Not sprayable	2.1
Remarks	Superior surface smoothness after demolding, but changes over time, surface smoothness inferior to prior art	Superior surface smoothness but low deflection and inferior cracking resistance	Superior surface smoothness after demolding, but changes over time, surface smoothness inferior to prior art	Difficulty in spraying with sprayer, unable to form intermediate layer	No intermediate layer (B), in accordance with prior art

Table 4

	Mold temperature	Example 10	Comp. Ex. 5
Evaluation of surface smoothness of molding mold according to temp. changes	20°C	20.5	19.0
	40°C	20.4	18.5
	60°C	20.4	17.5
	80°C	20.2	15.5
Remarks		High surface smoothness maintained regardless of changes in mold temperature	Surface smoothness impaired by changes in mold temperature

The present invention provides a fiber-reinforced plastic molded article that has superior surface smoothness that is stable with respect to temperature changes, namely the surface of which is not affected by temperature changes, inhibits the occurrence of surface blisters with respect to hot water resistance, and has a large allowable range of the amount of deflection and deformation enabling it to prevent cracking of the surface layer, and provides its production method and its molding mold.

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